

Date: Monday, 4/30/2007 7:22:17 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: PLUG
Job Number	: 32099			
Estimate Number	: 12292			
P.O. Number	: N/A		Part Number	: D26513
This Issue	: 4/30/2007	S.O. No. : N/A	Drawing Number	: D2651 REV.B
Prsht Rev.	: NC		Project Number	: N/A
First Issue	: N/A		Drawing Revision	: B
Previous Run	: 31488		Material	: N/A
Written By			Due Date	: 5/4/2007 Qty: 300 Um: Each
Checked & Approved By				
Comment	: est rev. A 06.02.15 new issue EC			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 3732c\07/05/09

Purchase P/N: 2-008 as per Dwg D2651

300

Supplier: Parker

Ensure Certificate of Conformity is attached

2.0	MS28775008	O RING
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 300.0000 Each(s)

O RING

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

E Posz/05/11

Ensure material certification is attached

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D3446

Jones/05/14

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 52 44
7/5/09 59 300
PL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/05/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: PLUG

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Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



(300)

Comment: FINAL INSPECTION/W/O RELEASE

4/30/07/05/14

Job Completion



u 4/05/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

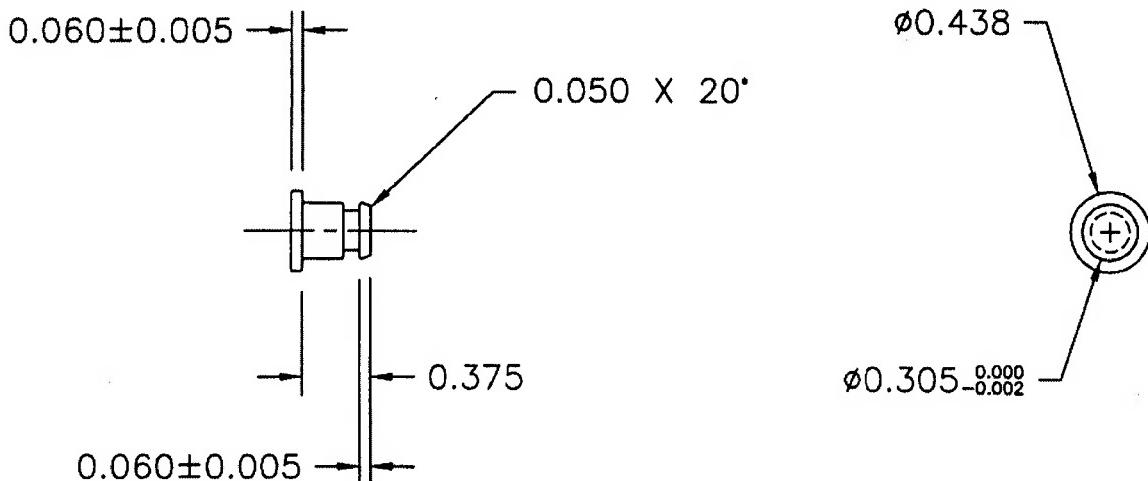
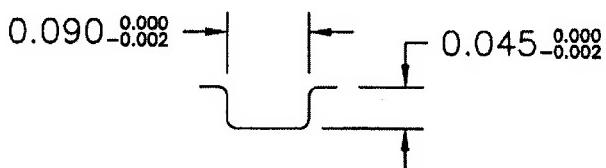
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D2651	SHEET 1 OF 1
DATE		TITLE	SCALE
03.12.19		PLUG	1:1
A	97.03.25	NEW ISSUE	
B	03.12.19	ADD POWDER COAT, MS28775-008	

RELEASED03.12.19 *[Signature]*D2651-1 PLUG:GROOVE DETAIL (SCALE 5:1)D2651-1 PLUG

- 1) MATERIAL: 6061-T6 (QQ-A-225/8) OR 1100-0 (QQ-A-225/1)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 MAX

D2651-3 O-RING

- 1) MATERIAL: BUNA N, 70 DUROMETER
~~3/16 ID, 5/16 OD, 1/16 WIDTH~~
(PARKER 2-008, MS28775-008 OR EQUIVALENT)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32099

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Parker Hannifin Corporation

O-Ring Division

Parker Seal de Matamoros
 Diagonal Lorenzo De La Garza #13 Ciudad
 H. Matamoros, Tam. 87499, Mexico
 Phone: (859) 335-3000

**— NOTICE —
 This is a C.B.I. Compound!**

C.B.I. is Parker's exclusive quality assurance program for Controlled Batch Identification, your assurance of reliability.

CONFORMANCE CERTIFICATE FOR MATERIAL SHIPPED

Parker O-Ring Division certifies that the material used in the manufacture of the parts identified below and called for on Purchase Order Number 179577 received by us from SWAN ENGINEERING & SUPPLY is traceable to C.B.I. Number 0080041710 and that the material used conforms to the requirements of the specifications indicated below. The tests were performed in accordance with these specifications, and data supporting the indicated results are on file.

ITEM NUMBER	ITEM DESCRIPTION	COMPOUND	QUANTITY	SHIURE DATE	SHIP DATE
MS28775-008	MS28775-008	N0304 -75	6288 2Q06		05/11/06
TESTED AS: 2-214 & BUTTONS					
PHYSICAL PROPERTIES					
SPECIFICATION MIL-P-25732c	TYPE	CLASS	VARIATION	PARKER FINDINGS	
ASTMD297 SPECIFIC GRAVITY			(1.26 - 1.30)	TEST DT 04/26/06	
ASTMD2240 HARDNESS SHORE A	(68 - 80)		(70 - 80)	1.2800	
ASTMD1414 TENSILE STRENGTH, PSI	1350 MIN		(1440 - 2160)	73	
ASTMD1414 ELONGATION, %	160 MIN		(160 - 226)	1543	
MODULUS AT 100% ELONG.	500 MIN		(500 - 9999)	187	
TR-10 50% ELONG. 10%RETURN	-49 MAX			569	
FLUID AGEING 70 HRS AT				-55.0	
275F IN MIL H-5606					
ASTMD395 COMPRESSION SET % MAX	55			34.0	
TR-10	-49 MAX			-49.0	
ASTMD2240 HARDNESS CHANGE	+5 -15			-10.0	
VOLUME CHANGE	1 +20			15.0	

E/Sast/15/11
P/10 3332

Testing Performed By PSDM Lab
 Diagonal Lorenzo De La Garza #13 Ciudad
 H. Matamoros, Tam. 87499, Mexico

No Mercury, Mercury compounds or Mercury bearing instruments, equipment or apparatus which might cause contamination has been used in the manufacture or subsequent processing of material covered by this order.

Purchaser use only. Reproduce only in full. Data pertains to items referenced.

The recording of false, fictitious or fraudulent statements or entries on the certificate may be punishable as a felony under federal law.

The information contained herein is submitted as the privileged and confidential property of the Parker Hannifin Corporation pursuant to 5 U.S.C. Section 552 (b)(3) and (b)(4), the Freedom of Information Act, exemption Number 3 and Number 4. This information shall not be duplicated, used or disclosed in whole or in part outside the recipient organization without express written consent of the Parker Hannifin Corporation.

O-Ring Division
PARKER HANNIFIN CORPORATION

By _____


 Ruben Ramirez
 Quality Assurance Manager